



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6798927-2

Job Sheet 195147



Part No: RB6798927-2

Job Qty: 4 pcs

Part Name: Crimper Jaw Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/14/19

Job Tracking No:

Due Date: 7/29/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG RB6798927 Rev.2 IPP Rev. A 18.05.30 new issue DP Verify DD

Ship Via:

STOCK @ RBO. 2 IS ACCEPTABLE PER
ECN 19-752 JULY 7/19

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	7/29/19	7/29/19	0.00	0.67	Large Fab - 1		CC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
110	QC 9	4 pcs	7/29/19	7/29/19	0.00	0.00	QC 9 - 10		JUN 0 4 2019
							QC 9 - 18	DAS 24	
							QC 9 - 24	9-89	
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
120	QC 5	4 pcs	7/29/19	7/29/19	0.00	0.00	QC 5 - 19		JUN 0 4 2019
							QC 5 - 22	DAS 24	
							QC 5 - 24	9-89	
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
130	Packaging 2-1 - Receive - B4B	4 pcs	7/29/19	7/29/19	0.00	0.00	QC 5 - 50		JUN 0 4 2019
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
140	Packaging 2-1 - Receive - B4B	4 pcs	7/29/19	7/29/19	0.00	0.00	QC 5 - 40		JUN 0 4 2019
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
150	Packaging 2-1 - Receive - B4B	4 pcs	7/29/19	7/29/19	0.00	0.00	QC 5 - 40		JUN 0 4 2019
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		
							QC 5 - 40		



Container No: S187119



Part: RB6798927-2

Job No: 195147

Serial No/Batch: S187119

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 06/04/19

Plex 5/14/19 4:54 PM Dart.Renwick.Jennifer

				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	OP JUN 12 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
150	QC 6	4 pcs	7/29/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
160	Packaging 3-1 - Stock - B4B	4 pcs	7/29/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - SA	4 pcs	7/29/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

DAS
67
9-8DARA
21

GA/39D

JUL 10 2019

QC 21 - SA - 53

Part Op 100 - Weld per dwg A/R Steel rod Batch: _____ - Weld as per DWG.
 Descriptions: 110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O)
 130 - Outside Processing - Black Oxide -Issue P/O to GROUPE ALTECH; PO 43647 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required
 140 - Receive & Inspect for Damage & Mat'l Certs
 150 - QC6- All purchased or subcontracted products
 160 - Identify as per dwg & Stock Location:
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB6798927-2A	Jaw Part	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5089234
RB6798927-2B	Jaw Part	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5093389

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	RB6798927-2A	4	4	0
	RB6798927-2B	4	4	0

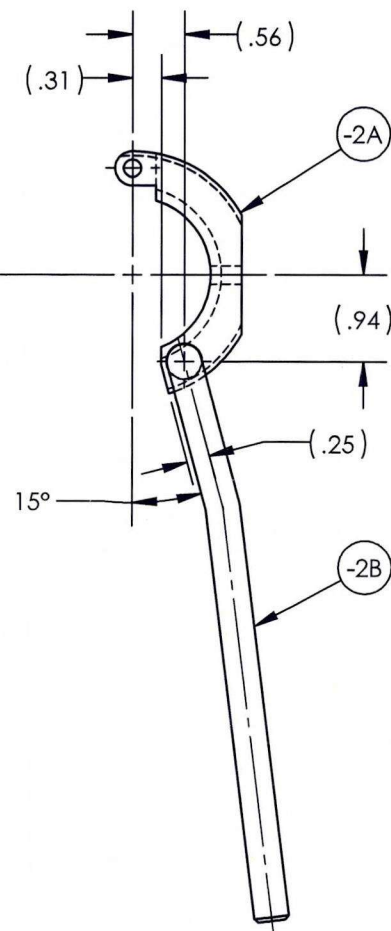
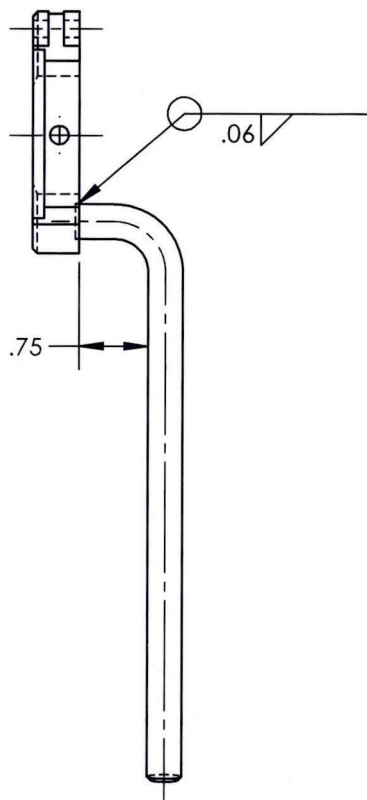
Part Specifications

Specifications could not be found.

Plex 5/14/19 4:54 PM Dart.Renwick.Jennifer

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	17-0107	-2 CH'D FINISH WAS CAD PLATE IS BLACK OXIDE QMSI-6.2.2, B.O. REV D.	4/27/2017	DPD	JAG



(-2)
CRIMPER JAW

URF 19-752 19.05.30 (VM)

DART AEROSPACE	
TITLE CRIMPER-LOCK NUT COMPRESSOR IMPELLER ASSY AND TURBINE POWER SHAFT	
DWG NO. RB6798927-2	REV 2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .010 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .02 ANGLES ± 1°
	.X ± .1 SURFACES = 125/
DRAWN BY: DD 04/27/2017	1. BREAK ALL SHARP EDGES
CHECKED: RJC 05/02/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/05/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/10/2017	AFTER PLATING
APPROVED: JAG 05/18/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 4/27/2017	250 SERIES
	SHEET 5 OF 8

Under Review Notification

Raised By: VANESSA MOREL

Date: 19.05.30

Product #: Dart Tooling ROLLS ROYCE

Product Name: COMPRESSOR IMPELLER ASSEMBLY

[illegible]**Description of Issue:**

FIT ISSUE

DWG WILL BE UPDATE BY ENG.

Distribution:

VP Operations

Director of Operations

Director Quality Assurance

QC Coordinator

Director of Engineering

Chief Engineer

Engineering Project Managers

Engineering Clerk

Customer Support Manager

Production Engineers

Production Planners

Purchasing Manager

Technical Support

Product Manager - Solutions Provider

Supply Chain Director / Senior Buyer

Marketing Eugene

H:\Forms\Engineering\Approved ENG Online\URF revE.xls



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043647



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043647

PO Date: 6/5/19

Due Date: 6/12/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-06

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195146	RB6798927-1	Jaw Weldment Outside Processing - Black Oxide) -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	6/12/19	4 pcs	0 pcs	4 pcs	\$3.636/pcs	\$14.54
2	195147	RB6798927-2	Crimper Jaw Weldment Outside Processing - Black Oxide -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; -Certificate of Conformity is required	Firmed	-	6/12/19	4 pcs	0 pcs	4 pcs	\$3.636/pcs	\$14.54



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PURCHASE ORDER

POHB043647



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	191523	RBE-350DAMPER	Damper Spanner Wrench -Issue P/O; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/12/19	7 pcs	0 pcs	7 pcs	\$3.636/pcs	\$25.45
				X7			JUN 11 2019			DP	
4	194416	RBST2162-11	Primary Seat -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	6/12/19	13 pcs	0 pcs	13 pcs	\$3.636/pcs	\$47.27
				X13			JUN 11 2019			DP	
5	194270	RBE350A93-3201-00-23	Sleeve -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	6/12/19	5 pcs	0 pcs	5 pcs	\$3.636/pcs	\$18.18
Grand Total:											\$119.99

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

[Handwritten signature]
6-6-19

Plex 6/6/19 9:43 AM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(019787-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.grouppaltech.com

Bon de Livraison / Packing Slip**019787 - 1**

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
12-Jun-2019		SPARTAKOS BOUNTOURIS				POHB043647			
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir / Back Order
1	RB6798927-1 Rev.	RB6798927-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A or MIL-PRF-81309 and wipe off excess	OXIDE-BLACK CH	4	4	0		0	0
2	RB6798927-2 Rev.	RB6798927-2 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A or MIL-PRF-81309 and wipe off excess	OXIDE-BLACK CH	4	4	0		0	0
3	RBE-350DAMPER Rev.	RBE-350DAMPER 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	7	7	0		0	0
4	RBST2162-11 Rev.	RBST2162-11 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	13	13	0		0	0

RECEIVED

JUN 11 2019

DART AEROSPACE LTD.

RECEIVED

JUN 11 2019

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.

ENGINEERING CHANGE NOTICE
DART AEROSPACE LTD

Date:	19.07.04	Job No.:	RB18-ROLLS ROYCE	ADR Yes/No:	N	ADR Date:		ECN #:	19- 752
Product No.:	DART TOOLING ROLLS ROYCE			Created By:	VM	Approved By:			
Product Name:	CRIMPER LOCK NUT COMPRESSOR IMPELLER ASSY			Checked By:	hmt				

Reason for Change:
TOLERANCE ISSUE

Documents Released:

RB6798927 REV C

IF APPLICABLE: NCR: _____ PAR: _____ CAR: _____ CIR: _____ URF: 19/52

PAPERWORK UPDATE ☐ PARTS MUST COMPLY ☐ PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance / Customer Support Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Airbus	N			
3	Notify Leonardo	N			
4	Manufacturing Licensing Agreement Update	N			

#	Engineering Actions	Reqd	Resp	Notes	Complete
5	Required Documents/Drawings/Item ID's Under Review (URF)	N			
6	Update Master Document List (MDL)	N			
7	Update Document Record (DR)	N			
8	Update Product Compatability Matrix	N			
9	Notify TC / FAA of Change (eg. ICA, 8110-3)	N			
10		N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
11	Move / Update Electronic Files / Design Journal	Y	MD		mdf 19.07.04
12	Update Product Specification Files (Bluefiles)	N			
13	Update Approved/Preliminary Dwg PDF Files	Y	MD		mdf 19.07.04
14	Update Product Development Summary (STC applications)	N			
15	Update QSI 021 (TC/FAA STC) and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	MD		mdf 19.07.04
17	Update / Verify Authorized Release Certificate Database	N	mdf		mdf 19.07.04
18	Create / Update Change Record Form / Item Card Database	N	MD		
19	Create / Update Packaging Process Plan (PPP)	N			
20	Red Decals required on Packaging Process Plan (PPP)?	N			
21	Update Controlled Supplier Documents (Qpulse) Database	N			
22	Update Grey Project Binder / Electronic Project Folder	N			
23	Update D-Part / M-Drawing / DSI / DEO Master Binders	N			
24	Update "Royalty Paid to" attribute (Parts sold under Dart USA STC's)	N			
25					

Description / Action:

RELEASE RB6798927 REV C DRAWING
PLACE RB6798927 REV 2 IN SUPERCEED FOLDER
CLOSE URF 19-752
STOCK CAN BE USE AS IS

ECN Verified & Complete: _____ Date: _____